

Amendment to the Specification

Page 7, lines 1-9:

Figure 3a illustrates a bender/corrugator 40 which creates a first "L" upper longitudinal edge 36 and a second "chair" bend 44 along the lower longitudinal edge 38 of the metal sheet 30. In the preferred embodiment of the invention the first bend 42 forms, what will be termed in this document, an L-shaped bend with an angle of between 45 and 135 degrees with the metal sheet 30 and has a width of between 5 and 100mm, (depending on the thickness of the metal, the type of metal, and the size of the tank 10). In the preferred embodiment the second bend 44 has a horizontal portion 46 that is between 5mm and 100mm wide and a vertical portion 48 that is between 5mm and 150mm. In this document the term "chair bend shall mean a structure that has two parallel, elongated sheets of metal extending out on either side joined by a cross member with the angle between either sheet and the cross member being at least 45 degrees".

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Figures 6a and 6b illustrate the roller track 160 formed by an adjacent "L" bend 42 and chair bend 44 of the unwelded upper and lower edges 36, 38 of metal sheet 30. In the preferred embodiment of the invention the first bend 42 forms an L-bend angle of between 45 and 135 degrees with the metal sheet 30 and has a width of between 5 and 100mm, (depending on the thickness of the metal, the type of metal, and the size of the tank 10). In the preferred embodiment the second bend 44 has a horizontal portion 46 that is between 5mm and 100mm wide and a vertical portion 48 that is between 5mm and 150mm.

Referring to Figure 5b, the roller track 160 (shown in isolation in Figures 6a-b) is supported underneath by roller 119 (on which the "L" bend along the upper longitudinal edge rests) while roller 118 pushes downwards (on the chair bend along the lower longitudinal edge).